

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022622**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 008539

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 14E. The weld designations reviewed are as follows:

1. APBB1-095-016
2. APBB1-100-008
3. APBB1-108-002
4. APBB1-121-002
5. APBB1-122-003

Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020U-587 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067588. ZPMC

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Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2854.

SMAW repair welding of weld joint SEG3020BB-114 located on Anchor Plate to Vertical Shear Plate at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 062588. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WRR-20409.

SMAW welding of weld joint FB3316-001-010 located on Floor Beam at panel point 125 of OBG Segment 14W. ZPMC Welder is identified as 062572. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint SP3139-001-071 to 084 located on Side plate Stiffener at panel point 128.7 of OBG Segment 14W. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SP3138-001-071 to 084 located on Side plate Stiffener at panel point 128.7 of OBG Segment 14W. ZPMC Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint SEG3020AJ-259 located on Side Plate I-stiffener at panel point 126.5 of OBG Segment 14W. ZPMC Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3020AJ-272 located on Side Plate I-stiffener at panel point 127 of OBG Segment 14W. ZPMC Welder is identified as 051348. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

Flux Core Arc Welding (FCAW) welding of weld joint SEG3020K-302, 306 and 310 located on Bottom Plate Stiffener to Floor Beam at panel point 127 to 127.3 of OBG Segment 14W. ZPMC Welder is identified as 204730. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SEG3020L-113, 119, 125 and 131 located on Bottom Plate Stiffener to Floor Beam at panel point 127.3 to 127.5 of OBG Segment 14W. ZPMC Welder is identified as 066239. ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

FCAW welding of weld joint SA3232B-016 located on Deck Panel Diaphragm to Floor Beam at panel point 124.5 of OBG Segment 14W. ZPMC Welders are identified as 215676 and 048433. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable

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WPS-B-T-2232-ESAB.

FCAW welding of weld joint SA3232B-002 located on Deck Panel Diaphragm to Deck panel Diaphragm at panel point 123.5 of OBG Segment 14W. ZPMC Welder is identified as 048696. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint SEG3013-009 located on Deck Panel to Deck Panel of OBG Segment 13AW. ZPMC Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3013D-234 located on Deck Panel Diaphragm to Deck Panel Deck panel Diaphragm at panel point 119.65 of OBG Segment 13AW. ZPMC Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint SEG3013B-254 located on Deck Panel Diaphragm to Deck Panel Deck panel Diaphragm at panel point 120 of OBG Segment 13AW. ZPMC Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint SEG3013P-005 located on Deck Panel Diaphragm to Deck Panel Deck panel Diaphragm at panel point 118 of OBG Segment 13AW. ZPMC Welder is identified as 045213. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

FCAW welding of weld joint SEG3013-227 located on Deck Panel Diaphragm to Deck panel Diaphragm at panel point 118 of OBG Segment 14W. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer